

Date: Wednesday, 11/03/2009 1:06:12 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STRUT WELDMENT ASS'Y
 Job Number : 46129
 Estimate Number : 10678
 P.O. Number :
 This Issue : 11/03/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : 02/03/2009 Type : LARGE FAB ASSY
 Previous Run : 44483
 Part Number : D3443043
 Drawing Number : D3443 REVB
 Project Number : N/A
 Drawing Revision : B
 Material :
 Due Date : 13/03/2009 Qty: ¹⁰/₁₄ Um: Each
 Written By :
 Checked & Approved By :
 Comment : EST. REV. A 05.11.17 NEW ISSUE EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D34437 Tubing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part Number Description Batch
 1 D3443-7 TUBING B 46145 = 10x.

SP 09.03.18.

2.0 D34433 Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part Number Description Batch
 1 D3443-3 CLEVIS B 46146 = 10x

SP 09.03.18

3.0 238805 SS DOWEL PIN 3/4" LONG



Comment: Qty.: 1.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part Number Description Batch
 1 238-805 SS DOWEL PIN 3/4" LONG M 11689 = 10x

Batch

M 11689 = 10x
~~M 10503~~
 SP 09.03.12 (14)

4.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
 Weld assembly as per dwg D3443

SP 09.03.18 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/03/2009 1:06:12 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT WELDMENT ASS'Y

Job Number: 46129

Part Number: D3443043

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-03-18 (10)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

509/03/19 (10)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1-Mask holes as per dwg D3443

2-Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME:

~~8:00~~ 2:30pm

OVEN TEMPERATURE:

400°C

FINISH TIME:

3:00pm

JS

09-03-18

(10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 09-03-20 (10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 262 (sylvie)

JS 09/03/20 (10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

JS 09/03/20 (10)

Job Completion



JS 09-03-20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

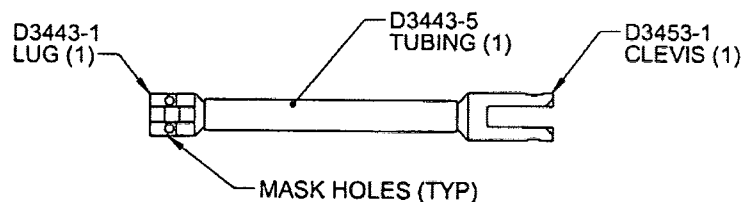
NOTE: Date & initial all entries



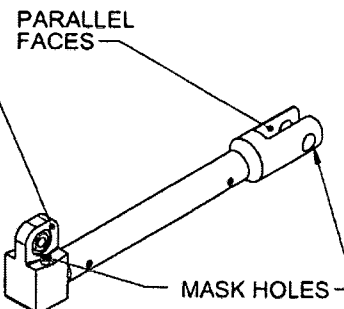
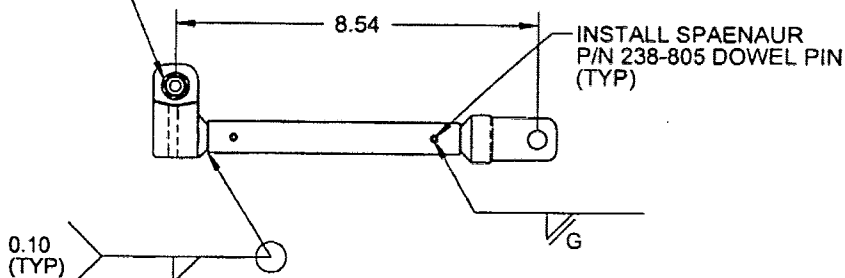
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CHECKED H	APPROVED H	DRAWING NO. D3443	REV. B SHEET 1 OF 3
DATE 05.12.05		TITLE STRUT WELDMENT ASSEMBLY	SCALE 1:4
A	05.09.02	NEW ISSUE	
B	05.12.05	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & Ø0.125 WAS #30	

RELEASED

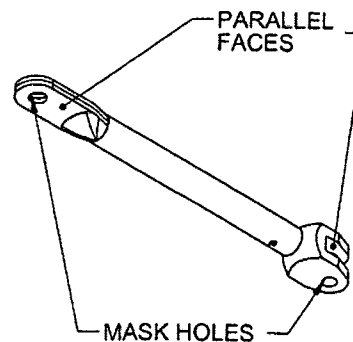
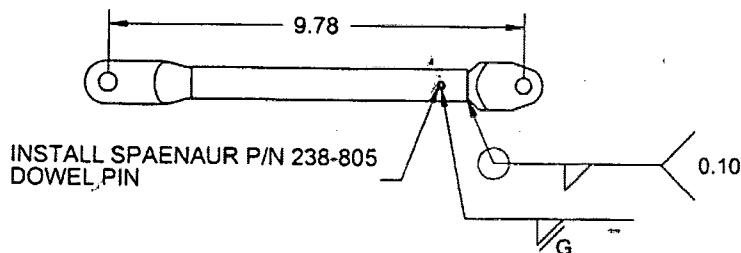
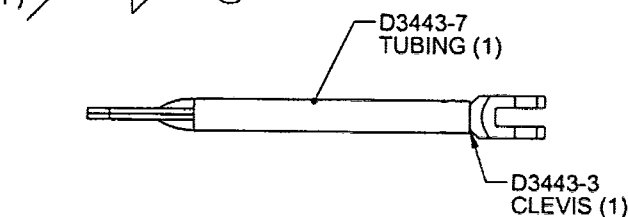
05.12.09 H



PRESS FIT McMASTER-CARR P/N 63215K32
BALL JOINT BEARING AFTER POWDER COAT



D3443-041



NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

D3443-043 COPY

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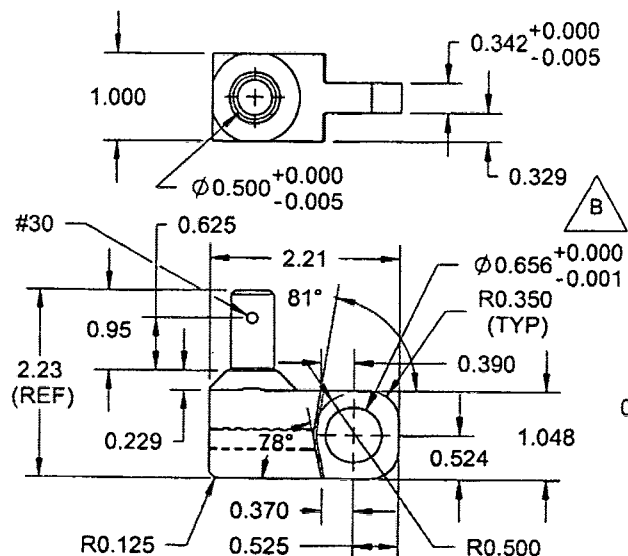
WORK ORDER

NO. 46129

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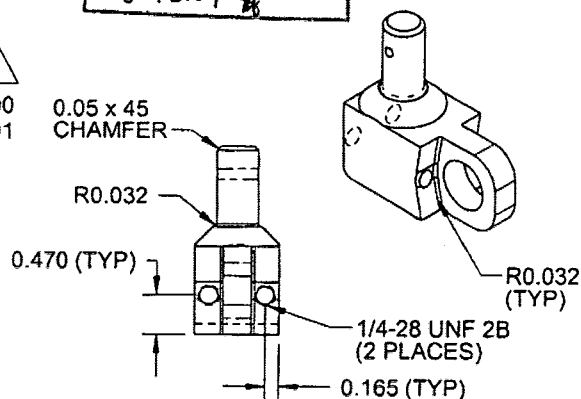
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CHECKED 	APPROVED 	DRAWING NO. D3443	REV. B SHEET 2 OF 3
DATE 05.12.05		TITLE SCALE STRUT WELDMENT ASSEMBLY 1:2	



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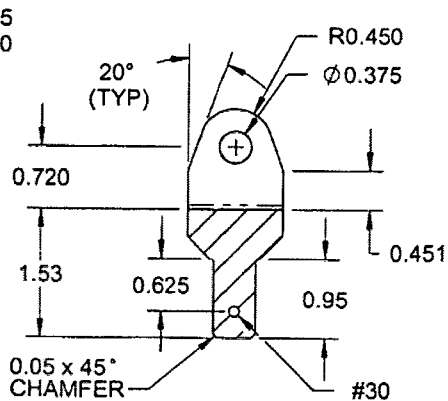
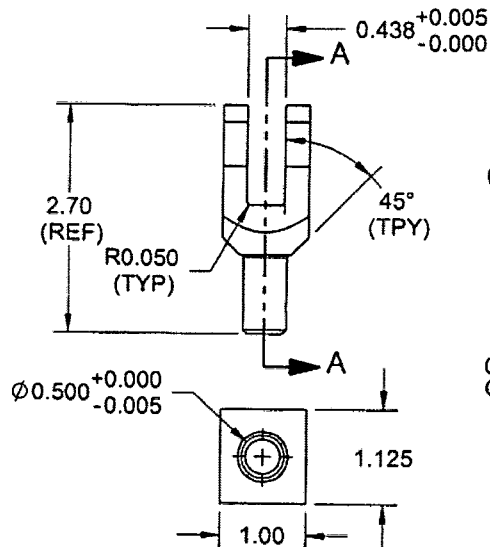
05.12.04



D3443-1 LUG

D3443-1 NOTES:

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)



SECTION A-A

D3443-3 CLEVIS

D3443-3 NOTES:

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)

GENERAL NOTES:

- 2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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NO. 4059

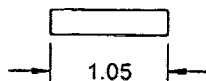
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3443	REV. B SHEET 3 OF 3
DATE 05.12.05		TITLE STRUT WELDMENT ASSEMBLY	SCALE 1:2

$\phi 0.210^{+0.005}_{-0.010}$



D3443-9 PIN

D3443-9 NOTES:

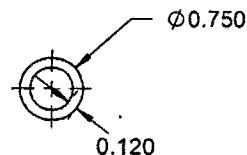
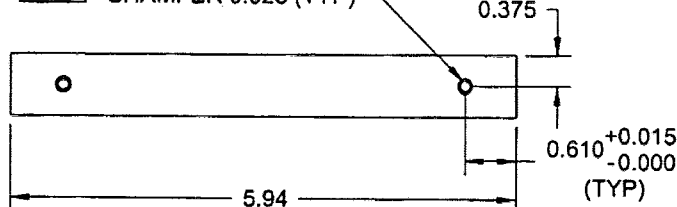
- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAIL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

05.12.09 [Signature]

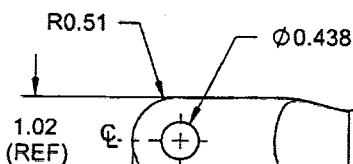
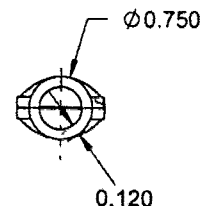
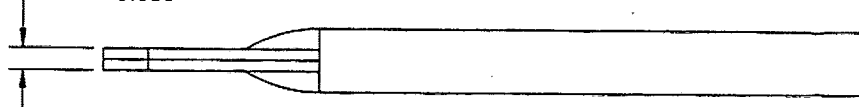


DRILL $\phi 0.125$ THRU
CHAMFER 0.025 (TYP)



D3443-5 TUBING

$0.260^{+0.000}_{-0.030}$



DRILL $\phi 0.125$ THRU
CHAMFER 0.025

D3443-7 TUBING

D3443-5/-7 NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.7500W120P)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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